

What is claimed is:

1. A method for controlling a slitter-scoring apparatus including the steps of supplying a paperboard sheet along a feed line, and moving a slitter or a scorer in a vertical and/or a widthwise direction to an operative level where the surface of said paperboard sheet is processed thereby

5 wherein:

movement of said slitter and/or scorer is controlled such that said slitter and/or scorer either comes into

10 sliding contact with or is apart slightly from said surface of the paperboard sheet.

2. A method as recited in claim 1, wherein the maximum distance between said slitter and/or scorer and said surface of the paperboard does not exceed more than 10 mm when said

15 slitter and/or scorer moves from a first widthwise position of a first operative level to a second widthwise position of a second operative level.

3. A method as recited in claim 2, wherein said slitter and/or scorer is moved simultaneously in said vertical direction and in said widthwise direction so that said slitter and/or scorer moves diagonally toward said second widthwise position when said slitter and/or scorer moves from said first widthwise position of said first operative level to said second widthwise position of said second

25 operative level.

4. A method as recited in claim 3, wherein said diagonal movement of said slitter and/or scorer occurs while said slitter and/or scorer is positioned in said paperboard

sheet.

5. A method as recited in any one of claims 2 to 4, wherein a path of movement of said slitter and/or scorer forms a plurality of straight lines which have a generally convex shape which is oriented in such a way that the nearer said straight lines come to its peak, the more said straight lines come apart from said surface of said paperboard sheet.

6. A method as recited in any one of claims 2 to 4, wherein a path of movement of said slitter and/or scorer 10 forms a curved line which has a generally convex shape which is oriented in such a way that the nearer said straight lines come to its peak, the more said straight lines come apart from said surface of said paperboard sheet.

7. A method as recited in claim 1, wherein said slitter 15 having an anvil positioned relative to a slitter blade of said slitter such that said paperboard sheet will be clamped therebetween, and said operative level being adjusted in accordance with the depth of the wear of said anvil during a setup step of said operative level so that said slitter 20 blade penetrates into said anvil.

8. A method for controlling a slitter-scoring apparatus including the steps of supplying a paperboard sheet along a feed line, and moving a slitter or a scorer in a vertical and/or a widthwise direction between an operative level 25 thereof where said paperboard sheet is processed and a retracted level where jam-up of said paperboard sheet is avoided, further including the step of:

positioning said slitter and/or scorer in a standby

position which is more proximal to said surface of said paperboard than said retracted level, while said slitter and/or scorer does not work upon said surface of said paperboard.